

Work Order ID 74294

Wednesday, September 28, 2011 7:29:02 AM

Page 1



Item ID: D3282-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Float Web (206L/407)

Start Date: 9/28/2011 Start Qty: 10.00

Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals: Process Plan: *[Signature]*

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3282

D

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut to length as per Dwg D3282.
2- inspect for surface damage as per QSI0018
3- Deburr

(X10)

OK 11/09/29

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA579 & Dwg D3282
2-Deburr

B.A 11/12/03

10 1 X

Pto ->

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B.A 11/12/04

10 1

W/O: 74294		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3282-041 PAR #: _____ Fault Category: Machining NCR: Yes No DQA: 11/12/2011 Date: 19/12/2011
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 11/12/20 Date: 11/12/20

NCR: 11-1077		WORK ORDER NON-CONFORMANCE (NCR) # 263.49						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/12/03	110	.050 step in mid-section of web in machine down to 0.000 (there's no step at all) Program was going at Z-.050" and Z0.0 in same program.	GP 11/12/05 PS/042	Fix program (J-F Sauvé) → Scrap + Destroy Replac B 72839	PS B.A 11/12/05	PS 11/12/06	GP 11.12.05 PS/042	S 11/12/05
		RC. Programming error Polil was clean + Dig is correct. LOA	GP 11.12.05				GP 11.12.05	S 11/12/05

NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

conf 11/2/06

10

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

MO 11-12-07

150

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

DP 11-12-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 3

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Required Date: 10/14/2011 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:




SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
	Skidtubes					10	0	SAD	11-12-07
Skidtubes	Memo	0.00							
Skidtubes	1-Install doublers as per Dwg D3282.								
170		0.00							
	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
180		0.00							
	Identify as per dwg & Stock Location: <u>LG</u>	0.00							
Packaging	Memo	0.00							
Packaging									



11-12-9

MD 11-12-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/12/14

mf

11-12-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Wednesday, September 28, 2011 7:28:59 AM

Page 1

Work Order ID: 74294

Parent Item: D3282-041

Parent Item Name: Float Web (206L/407)



Start Date: 9/28/2011

Required Date: 10/14/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:B 105.09.23 Procedure change KJ/JLM remove LPS as per dwg revD DD verf:JLM IPP REV:C 11.09.20

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2792-130

Manufactured

No

100

Each

62.0000

1

10



EXTRUSION

Location

Loc Qty

Loc Code

MAT06

62

72839

62

10 + 1 = 11

D3283-1

Manufactured

No

160

Each

25.0000

2

20



Doubler

Location

Loc Qty

Loc Code

ST045

25

66947

9

73611

16

9

11

SAD 11-12-07

MS20470AD4-7

Purchased

No

160

Each

2,304.000

57

570



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST320

2304

116081

117

117887

839

118614

1348

570

SAD 11-12-07

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <i>747294</i>
Description: Float Web		Part Number: D3282-041
Inspection Dwg: D3282	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.600	✓		Tape	GA-12
1.500	+/-0.010	1.500	✓		Vern	GA-01
3.000	+/-0.010	3.000	✓		"	"
6.000	+/-0.010	6.000	✓		"	"
1.250	+/-0.010	1.250	✓		"	"
30.000	+/-0.010	30.00	✓		Tape	GA-12
1.500	+/-0.010	1.500	✓		Vern	GA-01
72.01	+/-0.030	72.01	✓		Tape	GA-12
61.75	+/-0.030	61.75	✓		"	"
57.50	+/-0.030	57.50	✓		"	"
49.19	+/-0.030	49.19	✓		"	"
43.94	+/-0.030	43.94	✓		"	"
39.69	+/-0.030	39.69	✓		"	"
26.68	+/-0.030	26.68	✓		"	"
0.55	+/-0.030	0.551	✓		Vern	GA-01
1.970	+/-0.010	1.972	✓		"	"
2.38	+/-0.030	2.380	✓		"	"
0.05	+/-0.030	0.049	✓		D-6	GA-08

Measured by: <i>B.A</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: <i>11/12/04</i>	Date: <i>11/12/06</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

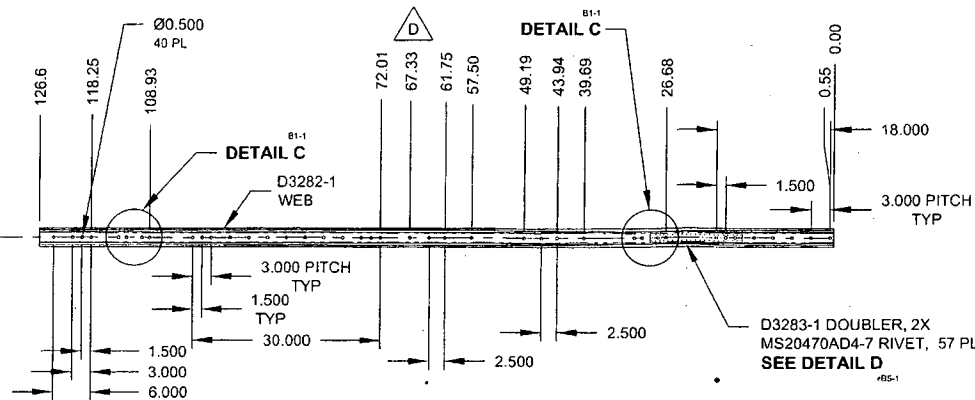
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

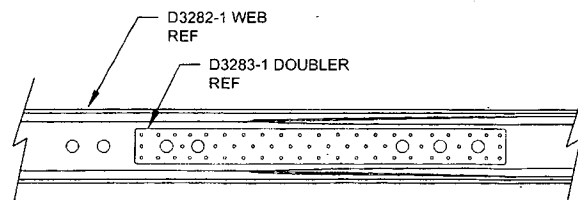
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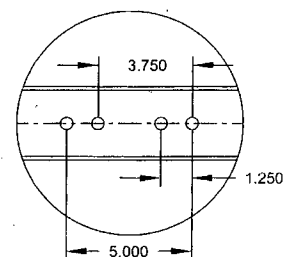
NOTE: Date & initial all entries



D3282-041 WEB



DETAIL D
C4-1



DETAIL C
D5-1
D6-1

NOTE: RIVET HOLES/DOUBLER
NOT SHOWN FOR CLARITY

RELEASED
2011-09-12

w/b 74294

NOTES:

- 1) MAKE D3282-1 WEB FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D3282-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 20.0 lbs
- 8) SEE PAGE 2 FOR MACHINING DETAILS

D	ADD ADDITIONAL HOLE (ZN D6-1); REMOVE LPS-3 (ZN C3-1)	SC	11.05.05
C	REMOVE D3390-1, NOW MACHINED	CP	05.08.09
B	MOVE HOLES, ADD D3390-1 DOUBLERS	CP	05.03.16
A	NEW ISSUE	CP	04.05.05
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	<i>JP</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>JP</i>	D3282	SHEET 1 OF 2
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	WEB	NTS
DATE	11.05.05	<small>COPYRIGHT © 2004 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC</small>	

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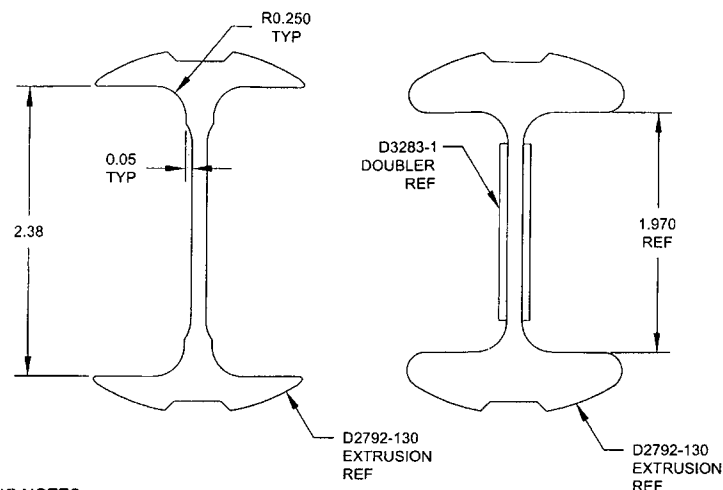
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8 7 6 5 4 3 2 1

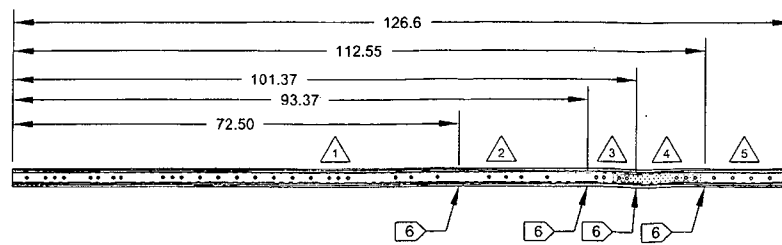
SECTION A-A

SECTION B-B



D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
- 5 DRILL #30 (Ø0.128 REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1, SEE DETAIL D FOR REFERENCE
- 6 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



RELEASED
2011-09-12

DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	CP	DRAWING NO.	REV. D
MFG. APPR.	CP	D3282	SHEET 2 OF 2
APPROVED	CP	TITLE	SCALE
DE APPR.	CP	WEB	NTS
DATE	11.05.05	<small>COPYRIGHT © 2004 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

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